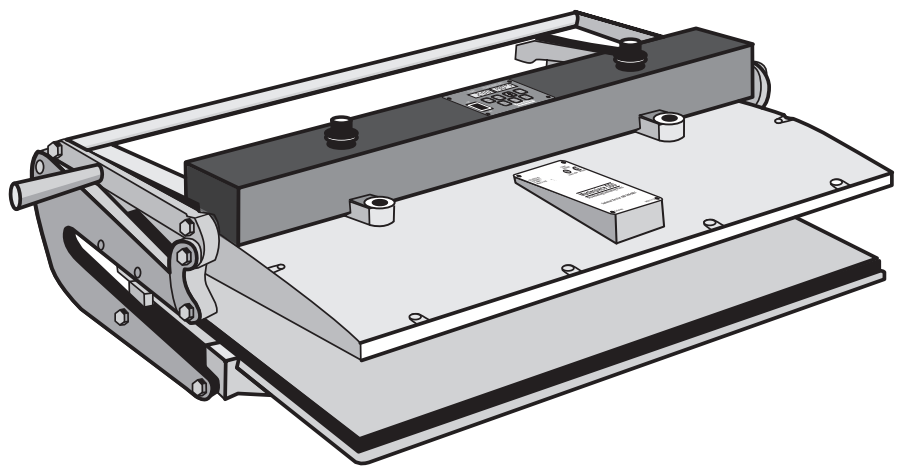




OWNERS MANUAL

Masterpiece® 550 and 250 Mechanical Dry Mounting/Laminating Press

Operation and Service



CONTENTS

Press Features and Specifications	2
Important Safeguards	3
Specifications	3
Identification of Controls	4
Installation and Preparation	5
Program Mode	5
Procedures For Use	6
Processing Oversize Materials	6
Pressure Adjustment Procedures	7
Wiring Diagram	8
Replacement Parts	9
Periodic Maintenance	9
Troubleshooting Guide	10
Warranty	11

PRESS FEATURES AND SPECIFICATIONS

- **Fast Operation:** Superior heating system quickly brings the platen to uniform temperature ensuring 100% bonding.
- **Extended Temperature Range:** Thermostat control adjusts from 100°F to 300°F (38° –150°C) to cover a wide range of operating temperatures.
- **Programmed Heating Cycles:** Temperature and time may be set by stored programs in control unit.
- **Temperature Readout:** Platen temperature is indicated on LED display on top of unit.
- **Cycle Time Readout:** Remaining time in the cycle is displayed.
- **Oversize Capacity:** Design allows processing of materials larger than the press platen by sliding the work side-to-side or out the front or back of the press.
- **Extra-Wide Opening:** Opens a full 9” (23cm) for 550 and 10” (25cm) for 250 to provide easy access to platen surface.
- **Easy Pressure Adjustment:** Pressure adjusts and locks in seconds to accept materials up to 1" (25mm) thick.
- **Non-Stick Surface:** Platen surface is specially coated to help keep adhesives from sticking.
- **Free-Floating Platen:** Seats evenly on the work without shifting to provide uniform pressure across the entire surface.
- **Rugged Construction:** Steel cantilevers increase durability and allow maximum pressure on work within the press. Metal top and base construction adds ruggedness.

IMPORTANT SAFEGUARDS

Please read the entire manual and fully understand the proper operating procedures before proceeding to use the press.

- 1. Place the heat press on a sturdy, flat, level table in a clean work area. The press should be accessible from three sides. The press should not be located in the direct path of air conditioning vents or room-cooling fans.
- 2. Correct pressure adjustment is essential to the safe and proper operation of the press and should be checked prior to every use.
- 3. Grasp the center of the handle firmly when opening and closing the press. Keep body, head and hands clear of all moving parts and away from the press opening at all times.

- 4. Objects such as knives, tools, rulers, paper clips and markers should be kept out of the press and away from the press opening at all times.
- 5. Proper maintenance of the press is easy and essential. The press platen and sponge pad should be kept clean and free of adhesive residue, and all functions should be checked periodically.
- 6. Turn the power switch off and keep in the closed (but not locked) position when not in use. Do not leave the press on overnight, and unplug the power cord while cleaning or replacing parts.

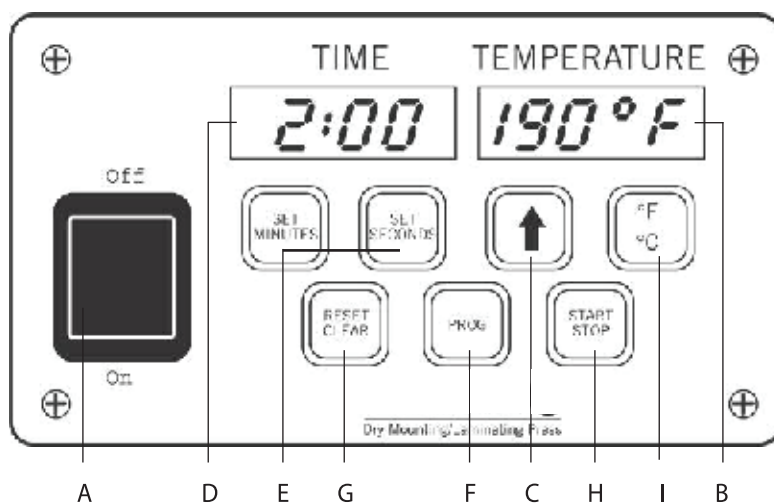
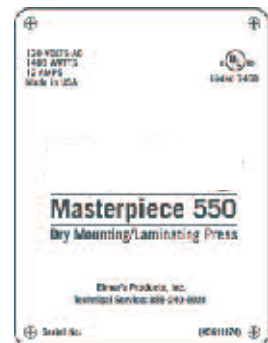
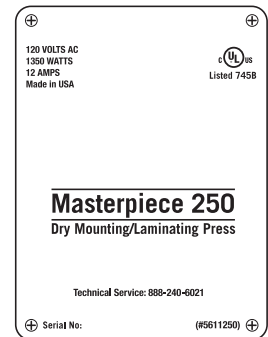
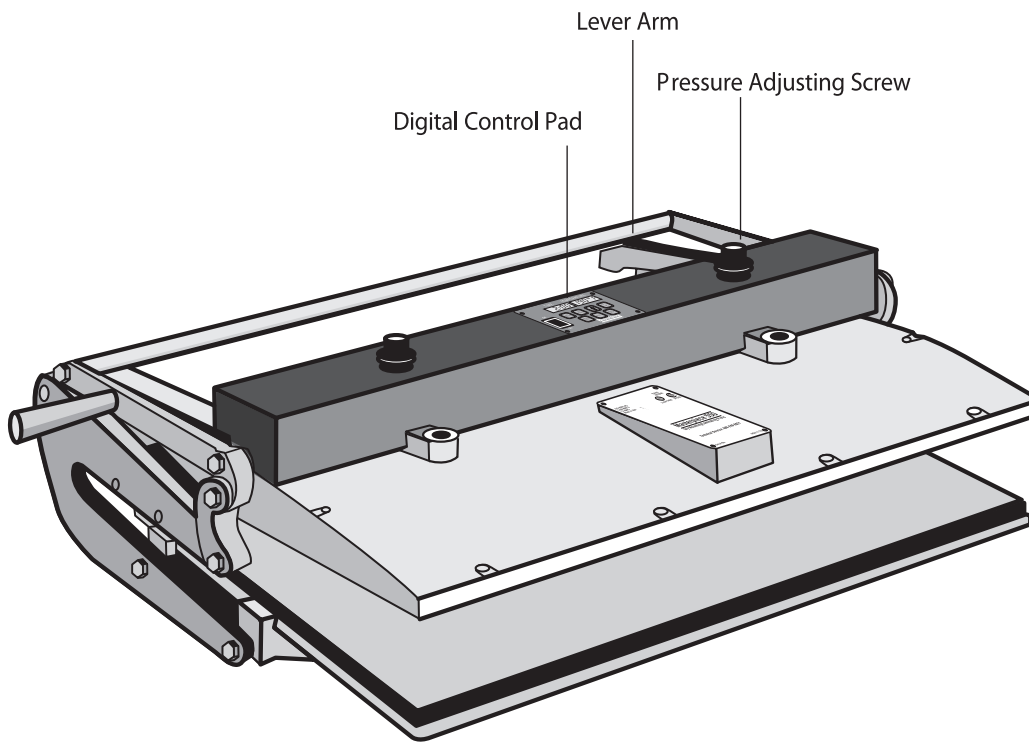
Contact an authorized Expression® dealer or D&K Technical Service (1-888-240-6021) in the event the press needs service or parts not covered in this Owners Manual.

SPECIFICATIONS

MASTERPIECE® 550		
Work Capacity:		
One piece	26" x 34"	
	66cm x 86cm	
Sections	50" (132cm)	
	by any length	
Dimensions:		
Width	39" (99cm)	
Depth	37" (94cm)	
Height	12" (30cm)	
Open	26" (66cm)	
Net Weight	210 lbs. (95 kg)	
Power Consumption	1,400 watts	

MASTERPIECE® 250		
Work Capacity:		
One piece	18.5" x 23"	
	47cm x 58cm	
Sections	36" (91cm)	
	by any length	
Dimensions:		
Width	27" (69cm)	
Depth	25" (64cm)	
Height	11" (28cm)	
Open	20" (51cm)	
Net Weight	72 lbs. (33 kg)	
Power Consumption	1,350 watts	

IDENTIFICATION OF CONTROLS



- A. Power Switch: Turns main power on/off.
- B. Temperature Display: Indicates set temperature or press platen temperature.
- C. Temperature Adjustment Button: Controls platen temperature. Set at 100°F (47.5°C) with the power switch on, the platen temperature should rise to 100°F (47.5°C) and cycle within +/- 5°F of that setting.
- D. Time Display: Indicates set time or remaining cycle time.
- E. Time Adjustment Buttons: Controls cycle time.
- F. Program Button: Activates pre-set and user set programs.
- G. Reset/Clear Button: Clears the displays for re-entry.
- H. Start/Stop Button: Stops and/or starts the current cycle.
- I. F°/C° Button: Switches between Fahrenheit & Celsius temperature display.

INSTALLATION AND PREPARATION

Your press is fully assembled and factory adjusted for immediate use. Install as follows:

1. Position the press squarely on a sturdy, flat, level table in a clean work area. Make certain that all four feet are resting on the surface. Access to the press from three sides is recommended. Making the adjacent table tops level with the sponge pad will facilitate handling oversize substrates.
2. Locate and identify all function controls (pg. 4).
3. Turn power switch off and plug the power cord into an outlet that is rated to supply the electrical current required for the press. See the Temperature Control Panel for specific information regarding the voltage required for proper electrical supply.

Masterpiece® 550 1,400 Watts
(Recommendation: Verify proper amperage before powering up)

Masterpiece® 250 1,350 Watts
(Recommendation: Verify proper amperage before powering up)

4. The press should be cleaned thoroughly before initial use. Expression® UnStik™ Adhesive Releasing Solvent or Expression® Platen Cleaner is suggested to fully clean the platen. Normal cleaning solutions can be used on the painted metal components. Clean only when press is cool and in a well-ventilated area.

The press is now ready for use. Check operation by closing (but not locking) the press and turning the power switch on. The power light should illuminate and the press should begin to warm up.

Please read the entire manual and fully understand the proper operating procedures before proceeding to use the press.

PROGRAM MODE

1. With the press turned on, press the "PROG" key.

The program number will display in the "seconds" position. The time and temperature will then appear on the display for the chosen program.
2. Continue pressing the PROG key to go to the next program setting. The first six programs are pre-set as follows:

	Time	Temperature		Application
Program 1:	2 min.	200°F	93°C	ColorMount®
Program 2:	2 min.	185°F	85°C	Fusion® 4000/ BufferMount®
Program 3:	3 min.	150°F	60°C	SingleStep® Plus
Program 4:	2 min.	180°F	82°C	SingleStep®
Program 5:	6 min.	215°F	102°C	Finish Guard™ UV (posters)
Program 6:	8 min.	215°F	102°C	Finish Guard™ UV (photos)

Programs 7–10 are for user-specific programs. The time and temperature may be input for these program numbers.

Once the time and temperature have been input to the desired settings, press and hold the PROG key for 5 seconds to store the settings.

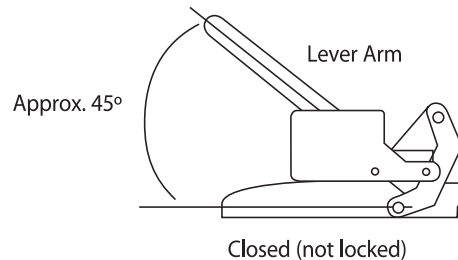
Once the desired program is reached, wait 5 seconds and the actual temperature will be displayed. The temperature will increase or decrease until the programmed temperature is reached. Once the programmed temperature is reached, press the START/STOP key.

PROCEDURES FOR USE

1. With the press in the closed (but not locked) position, turn the power switch ON. The control pad will be activated.
2. Normal operating temperatures of the press are 170-300°F (38-149°C). Refer to the specific instructions provided with supplies being used and set the press temperature display to stabilize the press at the Recommended Temperature setting.

NOTE: When mounting or laminating color photos or delicate materials, a temperature slightly lower than the Recommended Temperature may be used (no less than the Minimum Temperature setting for the specific adhesive or laminate). For heavier or thicker materials, or for faster results, a temperature slightly higher than the Recommended Temperature may be used (for best results, use lower temperature with longer dwell time).

3. Press the "SET MINUTES" key to increase the minutes to the desired setting. Press the "SET SECONDS" key to increase the seconds to the desired setting. Press the "UP" arrow key to increase the temperature to the desired setting. Once the desired setting is reached, the actual temperature of the press will be displayed within 5 seconds and will increase to the desired setting.
4. The press will reach the selected operating temperature and be ready for use in approximately 20-30 minutes. The degree symbol in the temperature display will blink rapidly until the operating temperature is reached... enough time should be allowed for it to stop blinking rapidly (slow blink to solid) before initial use to be certain that the platen temperature has stabilized.



5. Pre-dry the artwork and substrate (if needed) and assemble the materials to be processed. Refer to the specific instructions for the supplies being used.
 6. Check the pressure adjustment of the press by placing the assembled materials inside and closing (but not locking) the press. The lever arms should be at a 45° angle. Adjust the pressure, if needed, then close and lock the press.
 7. Press the "START/STOP" key to start the cycle.
NOTE: Assure that the temperature in the display is at the desired temperature.
- NOTE: See following section on Pressure Adjustment Procedures for proper pressure adjusting directions.
8. Leave the assembly in the press long enough to heat the materials to at least the Minimum Temperature indicated on the instructions provided with the adhesive or laminate being used (refer to the Time Chart in the instructions with the adhesive or laminate being used).
 9. Open the press, remove the assembled materials and cool them under an Expression® Weight to reduce bowing and improve the bond strength.

PROCESSING OVERSIZE MATERIALS

Materials substantially larger than the press platen can often be processed in multiple sections using the following precautions:

- Check that the pressure adjustment has been made to accommodate the thickness of materials.
- In the case of impressionable substrates (i.e. foam board) a Release Board or other buffer sheet slightly larger than the press platen may be placed over the materials; this helps prevent the possibility of platen lines appearing on the materials.
- Materials extending out of the press should be supported so that they do not bend or flex.

- When processing in sections, it is recommended to start in the center of the work and then work out towards the edges.

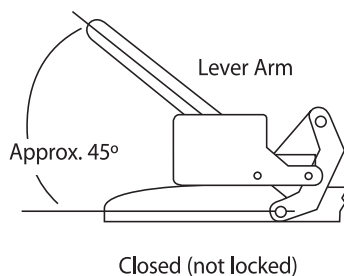
Pre-Drying Materials:

In humid, moist or damp conditions, certain porous materials absorb water and need to be pre-dried; this removes the excess moisture that would otherwise possibly interfere with good bonding or affect the finished appearance of the results. To pre-dry, place the materials inside a folder of smooth, porous paper or between 2 pieces of Kraft paper, and process for a short time.

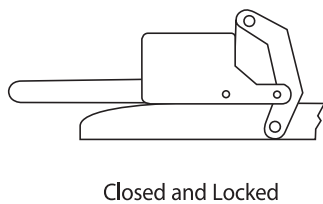
PRESSURE ADJUSTMENT PROCEDURES

Materials up to 1" (25mm) thick can be handled if the following pressure adjustment procedures are used:

1. Check the pressure adjustment of the press by placing the assembled materials inside and closing (but not locking) the press. The lever arms should be at a 45° angle to the top of the table as shown, if not, proceed to adjust the pressure.



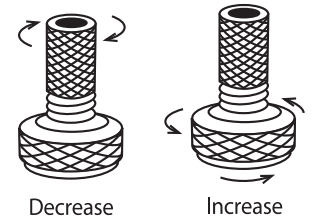
2. Close and lock the press, leaving the materials to be processed inside (or materials of equal thickness).



3. Loosen the knurled pressure locking nuts – (if the locking nuts do not loosen easily, open the press, insert an extra thickness of materials, close and lock the press, and then loosen the locking nuts. Remove the extra materials before proceeding to adjust the pressure).

4. Return the press to the closed (but not locked) position.

5. Turn each pressure-adjusting screw clockwise to lower the lever arms and decrease pressure, or counter clockwise to raise the lever arms and increase the pressure.



Make sure that the screws are adjusted so each arm is at the same 45° angle.

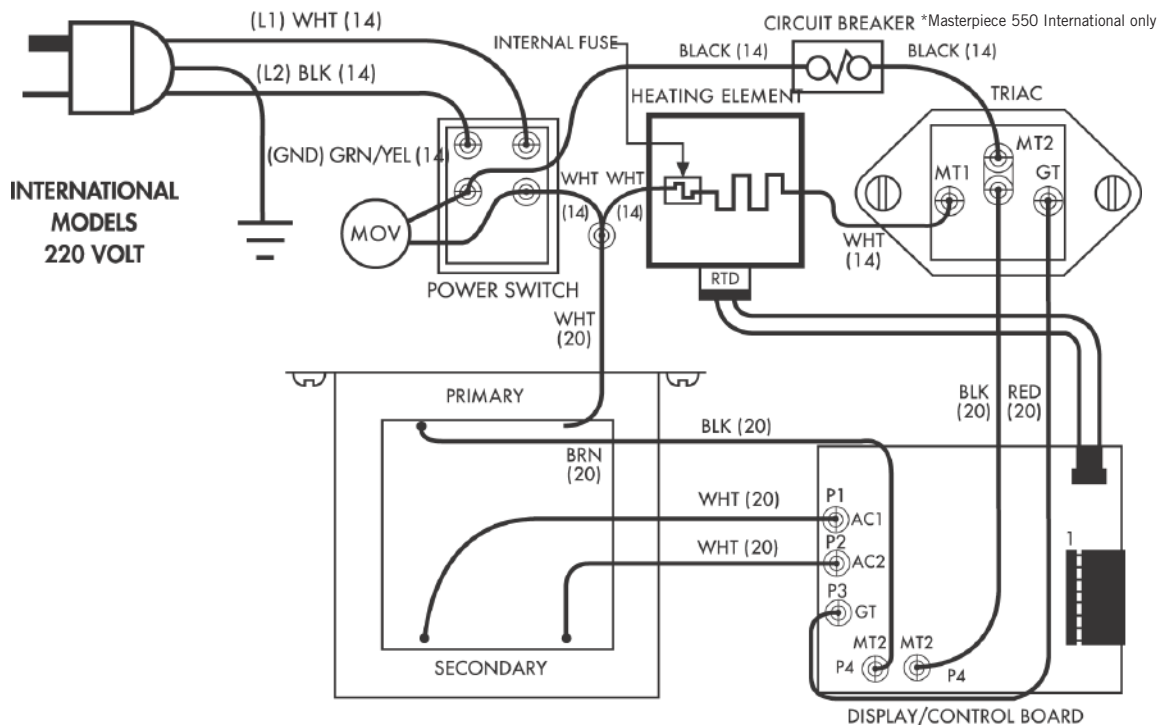
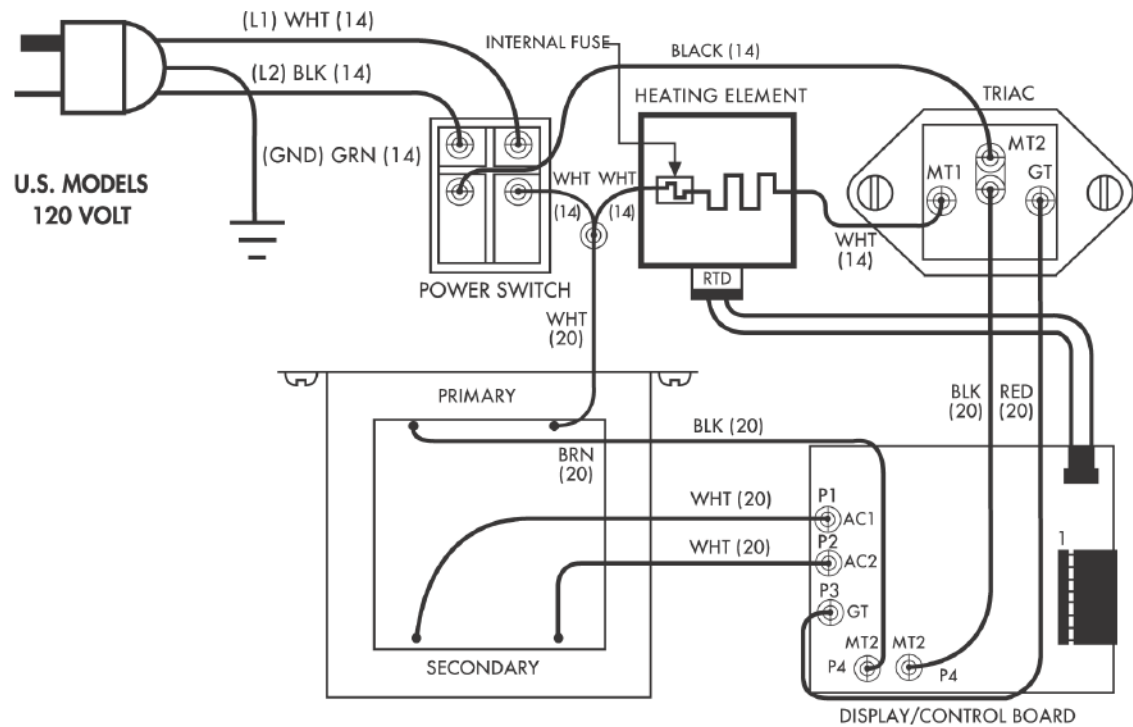
6. Return the press to the locked position and tighten each locking nut finger tight.

Alternative Pressure Adjustment Method

A shim can be made to simplify adjustment between two different thicknesses of substrates that are commonly used (example: 3/16" (5mm) foam board and 100 pt. card stock).

1. Set the pressure adjustment for the thicker of the two substrates (3/16" (5mm) foam board), using the preceding procedure.
2. Find a firm board that is equal to the difference in thickness between the two substrates (approximately 1/8" (3mm) in this example). Cut this board (to be used as a shim) the size of the pressure board beneath the sponge pad in the press.
3. Slide the shim under the pressure board when processing materials the thickness of the thinner board (100 pt. card stock). Remove the shim when using the thicker of the two substrates (the 3/16" (5mm) foam board).

WIRING DIAGRAM



REPLACEMENT PARTS

Masterpiece® 550	
Platen Kit	TS6299018
Sponge Pad	TS153260
Lever Arm – Right	TS100170
Lever Arm – Left	TS100171
Foot Kit	TS6299021
Toggle Plate/Bolt Kit	TS6299017
Crossbeam Bolt Kit	TS6299025
Handle Kit	TS6299028
Pressure Adj. Kit	TS6299031
Screw Kit	TS6299034
Control Assembly	TS2304084
Output Module	TS1408005
Sensor Assembly	TS6208059
Heater Kit	TS6299009
Electrical Kit	TS6299040
Transformer	TS2304083

Masterpiece® 250	
Platen Kit	TS6299019
Sponge Pad	TS143222
Lever Arm – Right	TS100223-1
Lever Arm – Left	TS100224-1
Foot Kit	TS6299022
Crossbeam Bolt Kit	TS6299026
Handle Kit	TS6299029
Pressure Adj. Kit	TS6299032
Screw Kit	TS6299035
Output Module	TS1408005 (210M-K)
Sensor Assembly	TS6208059
Control Assembly	TS2304084
Electrical Kit	TS6299040
Transformer	TS2304083
Heater Kit	TS6299141
Toggle Plate/Bolt Kit	TS6299024

- Kits listed above contain the components and instructions necessary for normal replacement of the affected item. This precludes the necessity of identifying and ordering individual parts and helps ensure all the necessary parts are on hand.
- If the supply cord is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person in order to avoid a hazard.

PERIODIC MAINTENANCE

The Expression® 550 Mechanical Press has been specifically engineered to require a minimum level of maintenance. The following guidelines were designed to keep the press in prime operating condition throughout its lifetime.

1. Clean the platen regularly. Expression® UnStik™ adhesive-releasing solvent or Expression® Platen Cleaner should be used to dissolve and remove difficult deposits as needed. Do not use abrasive materials such as steel wool or gritty cleaners.
2. Check the sponge pad periodically for cleanliness and uniform resiliency. If the pad shows any areas of soft or "dead" spots it should be replaced. Uniform pressure is essential for quality results when mounting or laminating. Replace the sponge pad as necessary when soiled or uneven.
3. Check the platen temperature periodically using temperature indicator strips to verify calibration of the thermostat and thermometer settings. Make sure the unit is warmed up and has stabilized to the set temperature. To recalibrate or replace call an authorized Expression® dealer or Expression® Technical Services.
4. Lubricate all pivot points twice a year with a Teflon® or

silicone dry lubricating spray. Oil or graphite lubricants are not recommended.

5. Inspect the power cord for breaks and cuts. Make sure there are no severe bends or crimps in the cord. The cord should not be pinched between the table, press or wall. If the cord needs to be replaced, please contact Expression® Technical Support at 888-240-6021. This should be done by the manufacturer only.
6. Check the overall press occasionally for levelness, loose screws, or damaged components. Adjust, tighten or fix as necessary.

Disclaimer

The information contained herein is based upon our research and believed to be accurate, but the accuracy and completeness of our recommendations is not guaranteed. The user shall determine the suitability of the product for their intended use, before using the product, and the user assumes all risk and liability whatsoever in connection with the use of the product. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or inability to use the product. The following is made in lieu of all warranties, express or implied. Seller's and manufacturer's only obligation shall be to repair, replace or credit such quantity of the product proved to be defective.

TROUBLESHOOTING GUIDE

LIMITED WARRANTY

D&K Group, Inc. warrants to the original consumer purchaser that each new Expression® equipment product which proves defective in materials or workmanship within the applicable warranty period will be repaired or, at our option, replaced without charge upon its return, postpaid, as outlined below. The applicable warranty shall be one year from date of purchase. "Original consumer purchaser" means the person who first purchased the product covered by this warranty other than for purposes of resale.

D&K's liability for breach of any warranty express or implied shall be limited to the repair or replacement, at D&K's option, of the defective item. D&K shall not be liable for damages, including but not limited to incidental or consequential damages, arising out of or in connection with the use or performance of any Expression® product.

To get performance under this warranty, contact Expression® Technical Support (1-888-240-6021) for assistance or to obtain a Return Authorization. If it is to be returned, pack the product securely to prevent damage in transit, and send the product, postpaid or freight prepaid, with a description of the defect or malfunction and proof of the date of purchase to D&K, Attn: RA Number. D&K is not responsible for damages from mishandling and abuse in transit, in which case a claim should be filed with the carrier.

This warranty extends to and is enforceable only by the original consumer purchaser, and only for the period (during applicable term) during which the product remains in the possession of the original consumer purchaser.

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Tech. Fax: 704-990-2204

Hrs: 8:00 a.m.-5:00 p.m. (EST)

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